

Work Order ID 130467

130467

Page 1

Item ID: D3199-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 3/12/15

Start Qty: 60.00

60

Cust Item ID:

Required Date: 3/20/15

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3199

E

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: E

Prog Rev: E

Deburr if required

(63)

DL 15/03/03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(63)

DL 15/03/13

Work Order ID 130467

March-12-15 11:20:49 AM

130467

Page 2

Item ID: D3199-1
 Revision ID:
 Item Name: Bracket
 Start Date: 3/12/15 Start Qty: 60.00
 Required Date: 3/20/15 Req'd Qty: 60.00
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

60
60

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>63</u>			DAS 38 9-89 MAR 13 2015
130 *130* Small Fab Small Fab	Small Fab Memo Form as per dwg D3199 use DT9723	0.00 0.00			DAS 30 9-89	<u>63</u>			MAR 25 2015
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00			DAS 28 9-89	<u>63</u>			DAS 38 9-89 MAR 30 2015

Work Order ID 130467

March-12-15 11:20:49 AM

130467

Page 3

Item ID: D3199-1
 Revision ID:
 Item Name: Bracket
 Start Date: 3/12/15 Start Qty: 60.00
 Required Date: 3/20/15 Req'd Qty: 60.00
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Start Qty: ***60***
 Req'd Qty: ***60***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150	<i>M 128564</i>					<i>63</i>	<i>15-3-31</i>		<i>238</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>3:20</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>4:00</i>								
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <i>ST 038A</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

63

APR 01 2015

DAS
27
9-89
63 APR 02 2015

Work Order ID 130467

March-12-15 11:20:49 AM

130467

Page 4

Item ID: D3199-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 3/12/15 Start Qty: 60.00

60

Cust Item ID:

Required Date: 3/20/15 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-02

H 15-4-2

Picklist Print

March-12-15 11:20:48 AM

Page 1

Work Order ID: 130467

130467

Parent Item: D3199-1

D3199-1

Parent Item Name: Bracket

Start Date: 3/12/15

Required Date: 3/20/15

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:C Removed Scribing 05-11-05 JLM
 IPP Rev:D As per Rev B 06-11-24 JLM IPP Rev:E
 11.03.31 as per ecn 11-531 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty.	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	371.1123	0.099	7			

M304S20GA

304/316 .040 Sheet

12/15/03/13

Location

Loc Qty

Loc Code

MAT

240

m131700

240

MAT020

131.1123

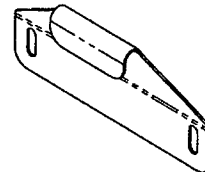
m130345

1.5139

m131060

129.5984

8.7



Technical drawing of a roof structure showing a cross-section. The drawing includes a horizontal line at the top, a vertical line on the right side labeled '2.24', and a dashed line indicating the roof profile. The roof has a flat top section and sloped sides. There are also dashed lines indicating internal structural elements or insulation.

Technical drawing of a mechanical part with dimensions: 15° REF, R0.17, 0.41, R0.25, 0.96, 0.68.

Wb
130467

RELEASED
2011-07-18

1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA

2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

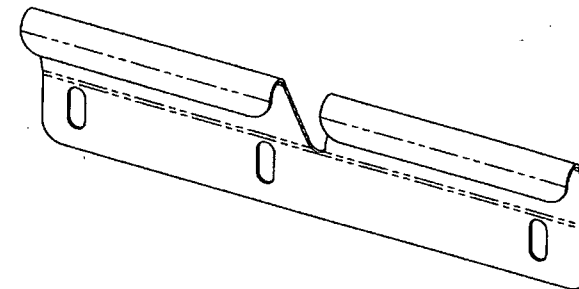
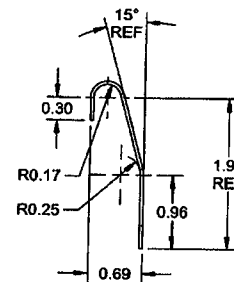
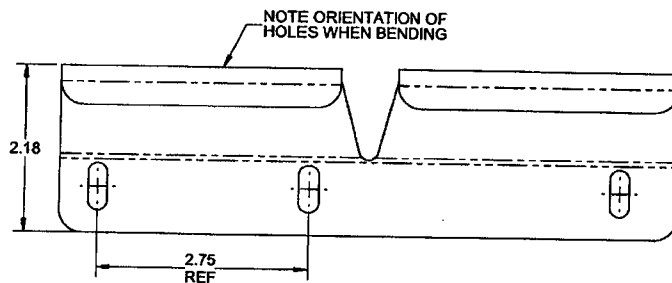
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1

7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/4 = 0.26 lbs EACH

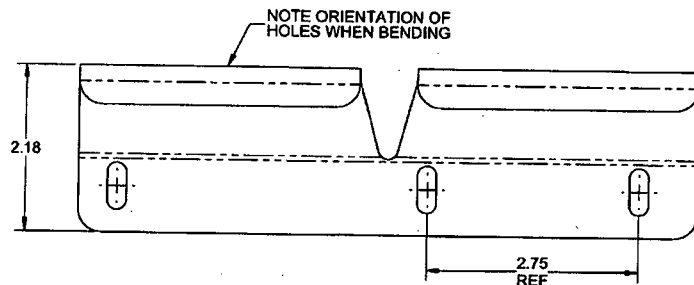
E	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT	MB	11.07.11
D	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PART 11-78	MB	11.03.21
C	ADD -3/4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3199 TITLE BRACKET	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.11	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



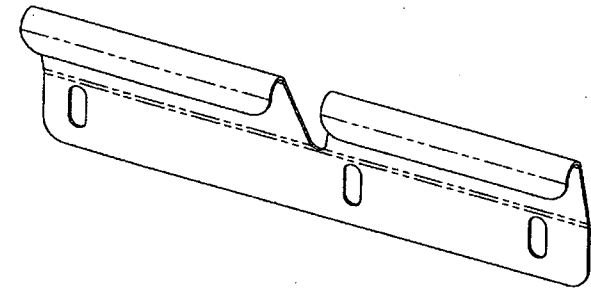
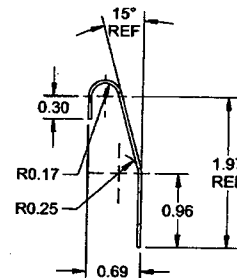
D3199-3 BRACKET
MADE FROM D3199-3F

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2011-07-18

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3199	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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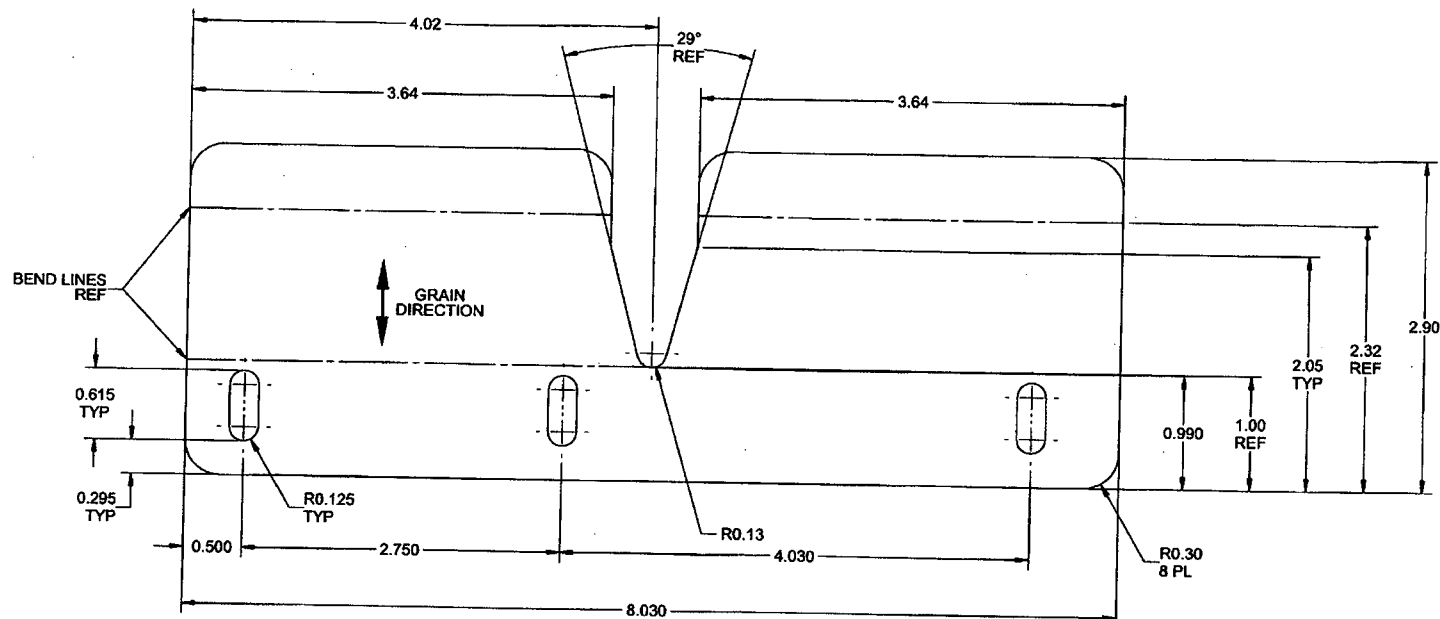


D3199-4 BRACKET
MADE FROM D3199-3F



RELEASED
2011-07-18
JMM

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D3199-3F FLAT PATTERN

RELEASED
2011-07-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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